

Work Order ID 92073

October-22-12 3:18:34 PM

92073

Page 1

Item ID: 647.1812

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Shim

Stop ***NS2***

Start Date: 22/10/2012 **Start Qty:** 78.00

78

Cust Item ID:

Required Date: 05/11/2012 **Req'd Qty:** 78.00

78

Customer:

Reference:

Approvals: Process Plan: ML5 Date: 12-10-22 Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop *NR2*

[illegible]

Work Order ID 92073

October-22-12 3:18:34 PM

92073

Page 2

Item ID: 647.1812

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Shim

Stop ***NS2***

Start Date: 22/10/2012 Start Qty: 78.00

78

Cust Item ID:

Required Date: 05/11/2012 Req'd Qty: 78.00

78

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours
15
9-89

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Outsource process-Anodize per QSI017 4.1.10.1

0.00

140

Outsource4

Memo

0.00

Outsource process - Anodize

ISSUE P/O: 18304
HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)

150

Receive & Inspect for Damage & Mat'l Certs

0.00

150

Packaging

Memo

0.00

Packaging

78
count

12-11-01

12/11/12 (78)

Work Order ID 92073

October-22-12 3:18:34 PM

92073

Page 3

Item ID: 647.1812

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Shim

Stop ***NS2***

Start Date: 22/10/2012 Start Qty: 78.00

78

Cust Item ID:

Required Date: 05/11/2012 Req'd Qty: 78.00

78

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

78

DAS
05
8-83

12 11 07

170

0.00

170

SprayPaint

Memo

0.00

Spray Painting

PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2)

CARDINAL 4860-50 PRIMER BATCH: 122543

78

0

0

Ad

12-11-19

180

QC14- Inspect Spray Paint

0.00

180

QC

Memo

0.00

Quality Control

DAS

12/11/19

(x) 78

(outs)

Work Order ID 92073

October-22-12 3:18:34 PM

92073

Page 4

Item ID: 647.1812

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Shim

Stop *NS2*

Start Date: 22/10/2012 Start Qty: 78.00

78

Cust Item ID:

Required Date: 05/11/2012 Req'd Qty: 78.00

78

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <i>SH/438</i>	0.00							
190									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

Per 4/21 *(38)*

12/11/22 *JD*

MF
12-11-21

Picklist Print

October-22-12 3:18:38 PM

Page 1

Work Order ID: 92073

92073

Parent Item: 647.1812

647 1812

Parent Item Name: Shim

Start Date: 22/10/2012

Required Date: 05/11/2012

Start Qty: 78.00

Required Qty: 78.00

Comments: IPP REV:A 12.10.03 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.063		Purchased	No			110	sf	40.4700	0.017	1.395789			
--------------	--	-----------	----	--	--	-----	----	---------	-------	----------	--	--	--

M2024T3S 063

2024-T3 .063 sheet

1.4

June-11-1

Location

Loc Qty

Loc Code

MAT022

40.47

119916

0.1

121197

16.32

123096

24.05

123096

THIS DRAWING IS THE PROPERTY OF APICAL INDUSTRIES, INC. IT IS TO BE USED ONLY FOR THE PURPOSES SPECIFIED HEREIN. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM APICAL INDUSTRIES, INC.

DATE	REV	BY	CHK
11/10/10	1	10/10/10	10/10/10
11/10/10	2	10/10/10	10/10/10

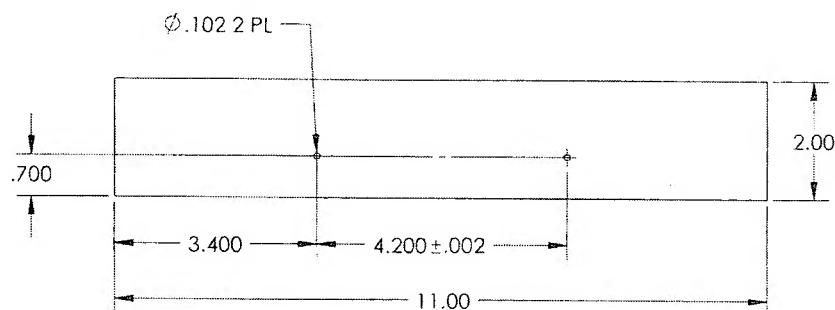
NOTES:

1. MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4

2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N

3. DEBURR AND BREAK ALL SHARP EDGES

4. IDENTIFY IAW MPP-120



647.1810

SHEDD
R. BRATO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

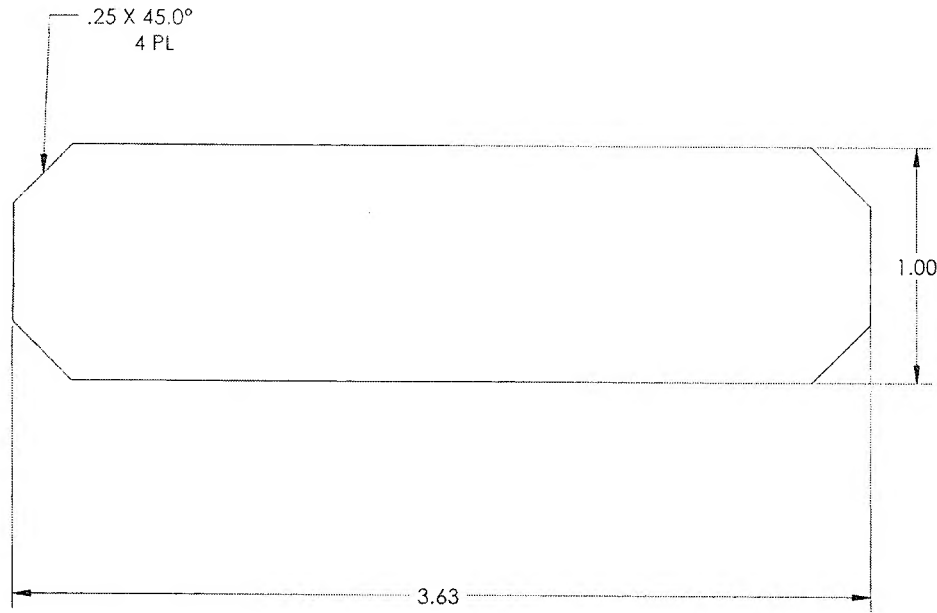
WITH NOTICE
WORK ORDER
NO. 920.73.MLS

12-10-22

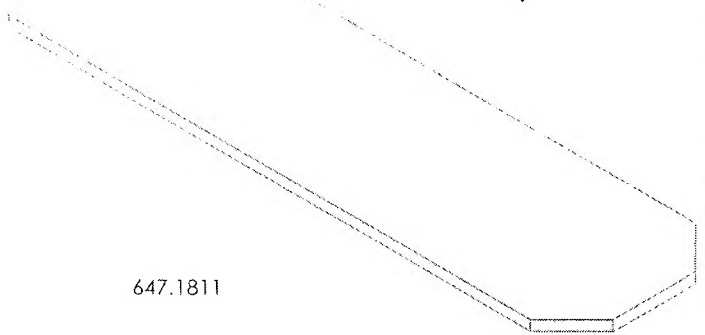
		647.1818	NOSE DOOR SPACER	△	△
		647.1817	SUPPORT, RH	△	△
		647.1816	SUPPORT, LH	△	△
		647.1815	GUSSET, RH	△	△
		647.1814	GUSSET, LH	△	△
		647.1813	ANGLE	△	△
		647.1812	SHIM	△	△
		647.1811	SPACER	△	△
		647.1810	NOSE DOOR DOUBLER	△	△
	FIND #	PART #	DESCRIPTION	MATL	SPEC.
QTY	PARTS LIST				
NEXT ASSY (S)	APICAL INDUSTRIES				
647.1300	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300				
	SHEETMETAL				
	ORIGINAL DATE	REVISED	REV.		
	11/10/10	11/10/10	1		
	11/10/10	11/10/10	2		
	11/10/10	11/10/10	3		
	11/10/10	11/10/10	4		
	11/10/10	11/10/10	5		
	11/10/10	11/10/10	6		
	11/10/10	11/10/10	7		
	11/10/10	11/10/10	8		
	11/10/10	11/10/10	9		
	11/10/10	11/10/10	10		
	11/10/10	11/10/10	11		
	11/10/10	11/10/10	12		
	11/10/10	11/10/10	13		
	11/10/10	11/10/10	14		
	11/10/10	11/10/10	15		
	11/10/10	11/10/10	16		
	11/10/10	11/10/10	17		
	11/10/10	11/10/10	18		
	11/10/10	11/10/10	19		
	11/10/10	11/10/10	20		
	11/10/10	11/10/10	21		
	11/10/10	11/10/10	22		
	11/10/10	11/10/10	23		
	11/10/10	11/10/10	24		
	11/10/10	11/10/10	25		
	11/10/10	11/10/10	26		
	11/10/10	11/10/10	27		
	11/10/10	11/10/10	28		
	11/10/10	11/10/10	29		
	11/10/10	11/10/10	30		
	11/10/10	11/10/10	31		
	11/10/10	11/10/10	32		
	11/10/10	11/10/10	33		
	11/10/10	11/10/10	34		
	11/10/10	11/10/10	35		
	11/10/10	11/10/10	36		
	11/10/10	11/10/10	37		
	11/10/10	11/10/10	38		
	11/10/10	11/10/10	39		
	11/10/10	11/10/10	40		
	11/10/10	11/10/10	41		
	11/10/10	11/10/10	42		
	11/10/10	11/10/10	43		
	11/10/10	11/10/10	44		
	11/10/10	11/10/10	45		
	11/10/10	11/10/10	46		
	11/10/10	11/10/10	47		
	11/10/10	11/10/10	48		
	11/10/10	11/10/10	49		
	11/10/10	11/10/10	50		
	11/10/10	11/10/10	51		
	11/10/10	11/10/10	52		
	11/10/10	11/10/10	53		
	11/10/10	11/10/10	54		
	11/10/10	11/10/10	55		
	11/10/10	11/10/10	56		
	11/10/10	11/10/10	57		
	11/10/10	11/10/10	58		
	11/10/10	11/10/10	59		
	11/10/10	11/10/10	60		
	11/10/10	11/10/10	61		
	11/10/10	11/10/10	62		
	11/10/10	11/10/10	63		
	11/10/10	11/10/10	64		
	11/10/10	11/10/10	65		
	11/10/10	11/10/10	66		
	11/10/10	11/10/10	67		
	11/10/10	11/10/10	68		
	11/10/10	11/10/10	69		
	11/10/10	11/10/10	70		
	11/10/10	11/10/10	71		
	11/10/10	11/10/10	72		
	11/10/10	11/10/10	73		
	11/10/10	11/10/10	74		
	11/10/10	11/10/10	75		
	11/10/10	11/10/10	76		
	11/10/10	11/10/10	77		
	11/10/10	11/10/10	78		
	11/10/10	11/10/10	79		
	11/10/10	11/10/10	80		
	11/10/10	11/10/10	81		
	11/10/10	11/10/10	82		
	11/10/10	11/10/10	83		
	11/10/10	11/10/10	84		
	11/10/10	11/10/10	85		
	11/10/10	11/10/10	86		
	11/10/10	11/10/10	87		
	11/10/10	11/10/10	88		
	11/10/10	11/10/10	89		
	11/10/10	11/10/10	90		
	11/10/10	11/10/10	91		
	11/10/10	11/10/10	92		
	11/10/10	11/10/10	93		
	11/10/10	11/10/10	94		
	11/10/10	11/10/10	95		
	11/10/10	11/10/10	96		
	11/10/10	11/10/10	97		
	11/10/10	11/10/10	98		
	11/10/10	11/10/10	99		
	11/10/10	11/10/10	100		

ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED
 ALL DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED
 ALL DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED

92073



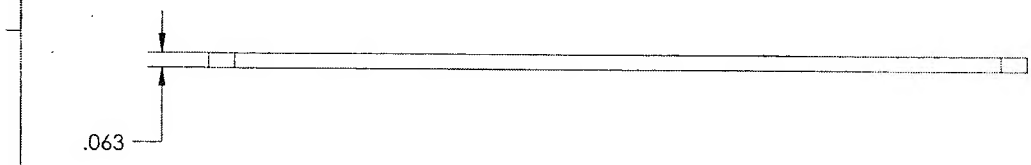
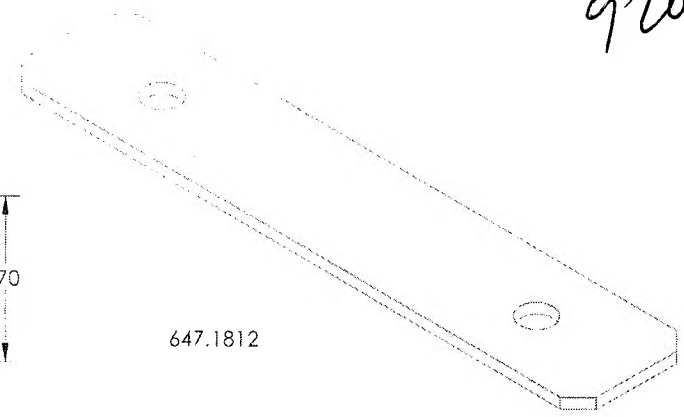
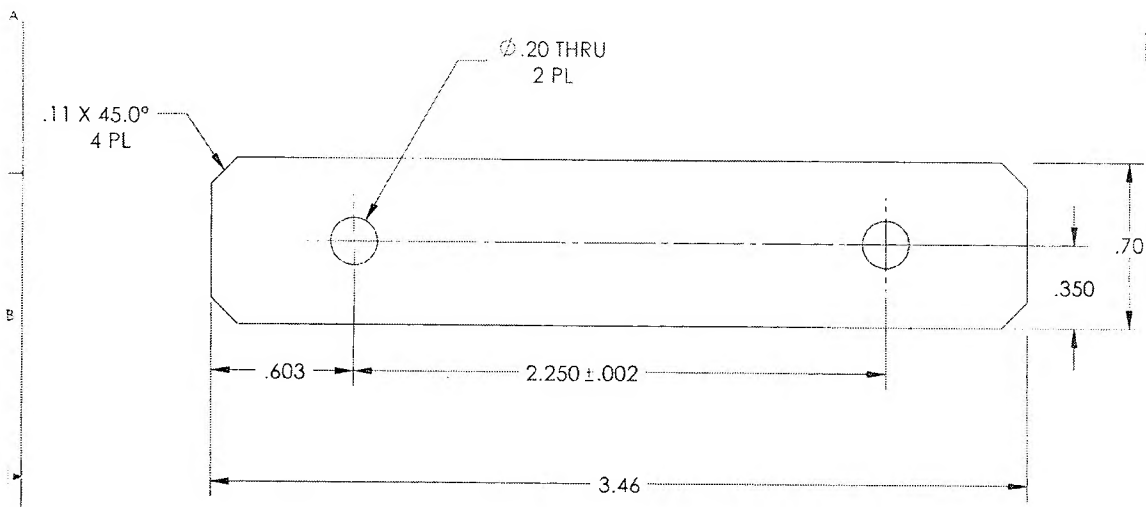
647.1811



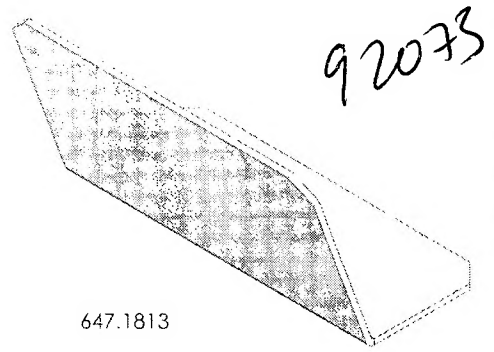
CUSTOMER DATE 08/01/09		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY P. MAING	CHECKED BY P. MAING	SHEETMETAL	
DESIGNED BY P. MAING	APPROVED BY P. MAING	SIZE B	DWG. NO. 647.1800
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .001 4 PLACE DECIMALS ± .0001	SCALE: NONE	SHEET 2 OF 7	REV N/C

ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED
 DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED
 DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED

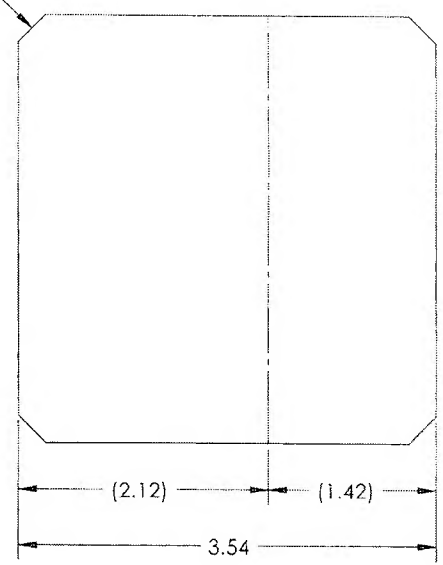
92073



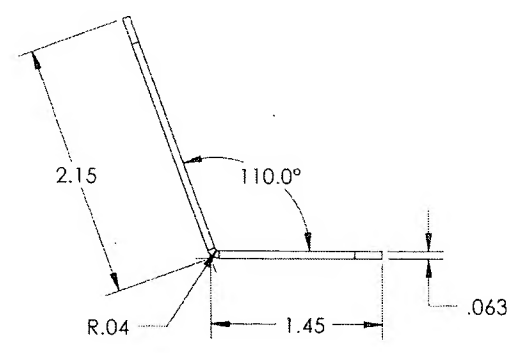
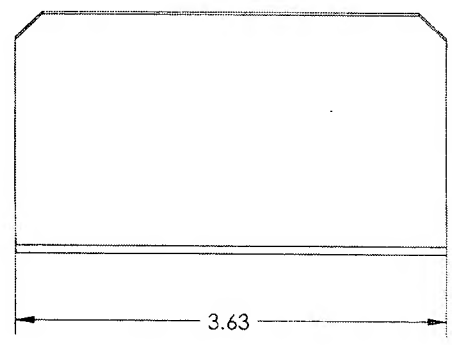
APICAL INDUSTRIES		2608 TEMPLE HEIGHTS DR.		OCEANSIDE, CA. 92056-3512 (760)724-5300	
SHEETMETAL		647.1800		REV N/C	
SCALE: NONE		SHEET 3 OF 7			



.23 X 45.0°
4 PL



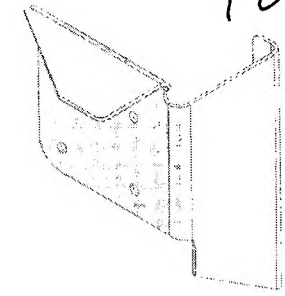
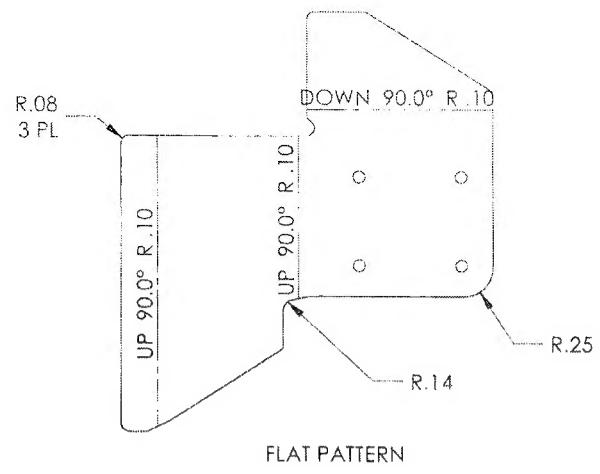
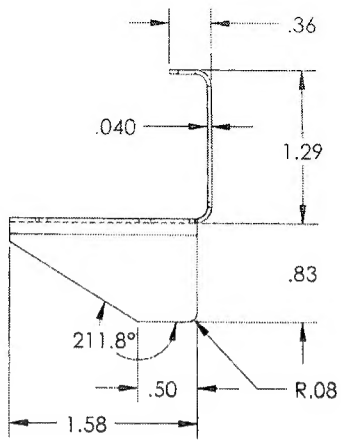
FLAT PATTERN



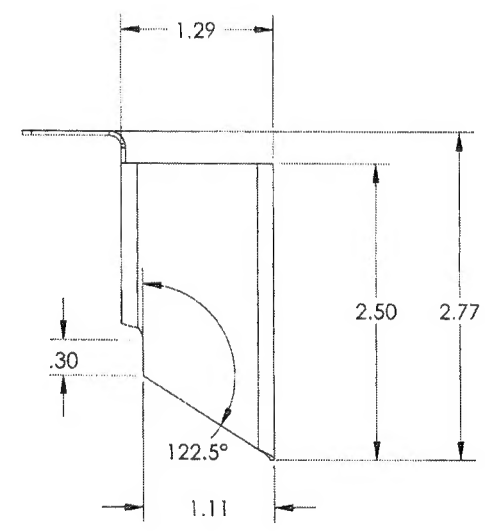
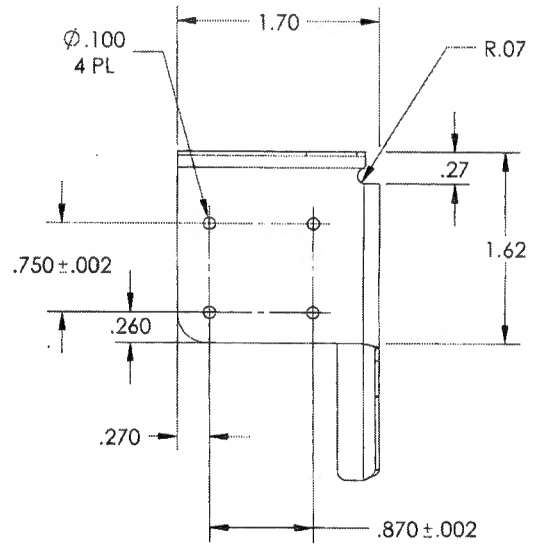
ORIGINAL DATE DWD BY: JPI DESIGN DRAWN BY: JCHIESE P. BRAY DRAWING APPROVAL P. BRAY DATE: 10/1/00 CO. PROJECT NO.		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR OCEANSIDE, CA 92056-3512 (760) 724-5300	
INSEE OVERLAP - SPECIFIC DIMENSIONS ARE IN INCHES UNLESS NOTED OTHERWISE 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .001 ATTACH B 5"		WE CASE CODE B 07M16	ENG NO 647.1800
SCALE: NONE		REV N/C	
		SHEET 4 OF 7	

ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED
 ALL DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED
 ALL DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED

92073

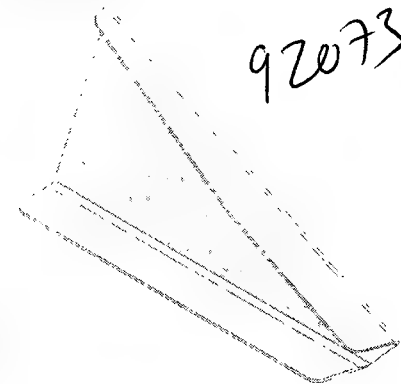


647.1814 SHOWN
 647.1815 OPPOSITE

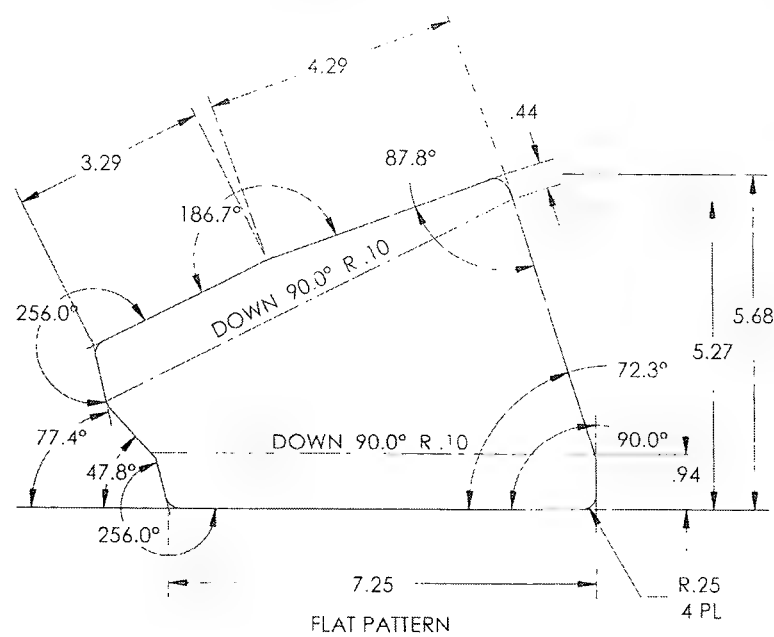
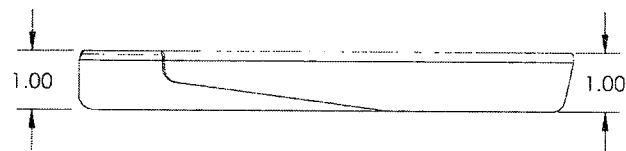


ORIGINAL DATE (MM-DD-YY)		APICAL INDUSTRIES	
DRAWN BY P. BRADY		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
CHECKED BY P. BRADY		SHEETMETAL	
CONTRACT NO.		647.1800	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS FRACTIONS DECIMALS FRACTIONS DECIMALS FRACTIONS DECIMALS FRACTIONS DECIMALS		SIZE B	REV. N/C
		SCALE: NONE	SHEET 5 OF 7

92073



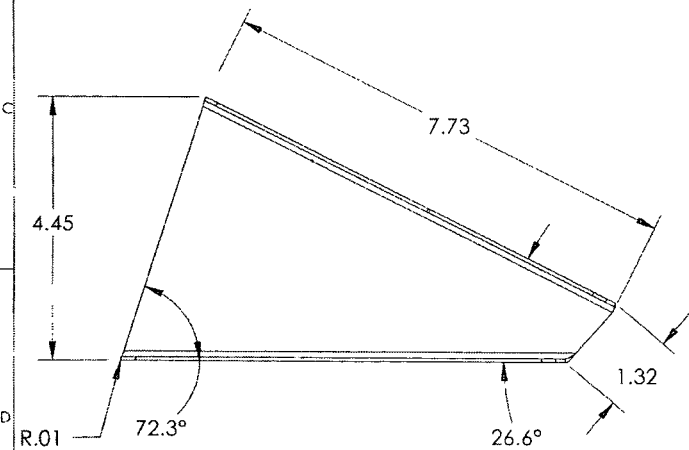
647.1816 SHOWN
647.1817 OPPOSITE



FLAT PATTERN



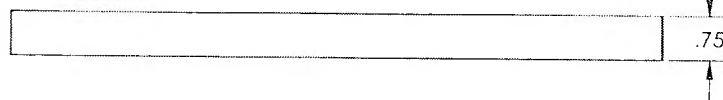
.063



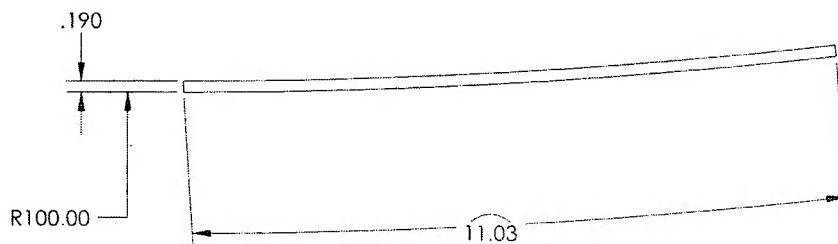
PROJECT DATA PROJECT NO. 08-12-07 DRAWN BY: DIRECTOR CHECKED BY: HAYO DESIGNED BY: APPROVAL P. BRAYO MODIFIED DATE		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. CCEANSIDE, CA 92056-3512 (760) 724-5300	
MATERIAL SPECIFICATIONS SHEET METAL THICKNESS: .063 GRADE: 304 FINISH: POLISHED		SHEETMETAL QTY: 1000 SCALE: NONE SHEET: 0 OF 2	
PART NUMBER: 647.1800 REV: 0/1/16 SCALE: NONE		647.1800 H/C	

IF ANY ADDITIONAL DIMENSIONS ARE REQUIRED, THE DIMENSIONS OF THE SHEET METAL SHALL BE THE DIMENSIONS OF THE SHEET METAL AS SHOWN ON THE DRAWING. THE DIMENSIONS OF THE SHEET METAL SHALL BE THE DIMENSIONS OF THE SHEET METAL AS SHOWN ON THE DRAWING.

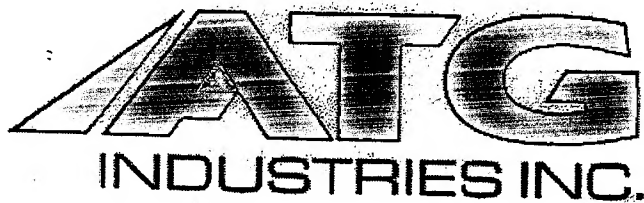
92073



647.1818



ORIGINAL DATE		APICAL INDUSTRIES	
REVISIONS		2608 TEMPLE HEIGHTS DR.	
REVISIONS		OCEANSIDE, CA 92056-3512 (760)724-5300	
REVISIONS		SHEETMETAL	
REVISIONS		SCALE: NONE	
REVISIONS		SHEET 7 OF 7	
REVISIONS		REV	
REVISIONS		NYC	
REVISIONS		647.1800	
REVISIONS		07/12/20	
REVISIONS		SCALE: NONE	
REVISIONS		SHEET 7 OF 7	



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62027

Date: 05-Nov-12

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
1 lot	Part: ASST 10 PCS 646.9813 10 PCS 646.9811 10 PCS 646.9812 10 PCS 646.9812 2 PCS 646.9811 15 PCS 646.4711 15 PCS 647.4716 15 PCS 647.4712 15 PCS 647.4717 15 PCS 647.4714 15 PCS 647.4715 15 PCS 647.4718 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20120674	Rev:	
		PO: PO18153	Line: 101214/7
1 lot	Part: ASST 7 PCS 647.1810 14 PCS 647.1811 91 PCS 647.1812 2 PCS 647.1612 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20120673	Rev:	
		PO: PO18304	Line:
Certificate of Conformance			



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62027

Date: 05-Nov-12

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To


DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via
Quantity	Description	
	<p>A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.</p> <p>ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY</p> <p>DATE: <u>5/12/12</u></p> <p>CERTIFIED SIGNATURE: <u></u></p> <p>RECEIVER SIGNATURE: _____</p>	